Mitsubishi Engineering-Plastics Corp.

Reny™ 1322

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

General Information

Product Description		
GF-reinforced; Rigidity, High; Impact Resistance, High		
General		
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight	
Features	• High Impact Resistance	• High Rigidity
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.60	g/cm³	ISO 1183
Molding Shrinkage [2]			Internal Method
Across Flow : 130°C, 2.00 mm	0.58	%	
Flow : 130°C, 2.00 mm	0.25	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	18100	MPa	ISO 527-1/1
Tensile Stress (Break)	245	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus [3]	16500	MPa	ISO 178
Flexural Stress [3]	387	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	17	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	94	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	225	°C	
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.6 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Hot Air Dryer, A	120	°C
Hot Air Dryer, B	80	°C
Drying Time		
Hot Air Dryer, A	> 3.0	hr
Hot Air Dryer, B	> 12	hr
Rear Temperature	265	°C
Middle Temperature	270	°C

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Injection	Nominal Value	Unit
Front Temperature	275	°C
Nozzle Temperature	275	°C
Mold Temperature	120 to 140	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate-Fast	
Screw Speed	60 to 150	rpm

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 100-mm square

[3] 2.0 mm/min